

Work Order ID 62580

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Monday, October 04, 2010 2:30:01 PM

Item ID: D412-742-043

Accept



Setup Start



Revision ID:

Stop



Item Name: Replacement Float Skidtube

Start Date: 10/4/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 10/15/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Handwritten signature

Date: 10-10-04

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3391

Rev H

100

0.00



DOCUMENT CONTROL

DC

0.00

Memo

Document Control

If D412-742-043 is a W/O on it's own,
Photocopy bluefile and create labels per PPP D412-742-043 CHG004*cd for RSG 10/12/23*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

110

0.00



HandFinish

HandFinishing

0.00

Hand Finishing

Memo

1-Install tubes together and seal them all the way around using Sikaflex
241/291. Ensure tube ends line-up with saddle holes for proper alignment. using
7/16" "T" Pins.
A/R ☐ Sikaflex-241/-291 ☒ 1115114
Expiry date: ☐ 11/01

2-Install wearplates as per Dwg D3391. Ensure that plastic washers are against
wearplate, then topped with the SS washer. Seal all bolts with sikaflex except
ones with inserts on inside of tube, hand tighten only bolts with no sikaflex.

A/R ☐ Sikaflex-241/-291 ☒ 1115114
Expiry date: ☐ 11/01

3-Remove "T" pins once sikaflex is dry.

4-Coat all exposed hardware with LPS Procyon. Remove any excess off with
MEK degreaser.
A/R ☐ LPS Procyon ☒ M114596

=> JH 10/12/16

1

0

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Customer:

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

S101216



130

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D412-742-043

Location: _____

PPP Rev: _____

PPP

10/12/228

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

CK 11/01/03

MF

10-12-23

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Picklist Print

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Work Order ID: 62580



Parent Item: D412-742-043



Parent Item Name: Replacement Float Skidtube

Start Date: 10/4/2010

Required Date: 10/15/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev A 05.10.13 New Issue KJ/JLM
 IPP Rev B 06.02.13 ECN 773 dwg @ rev.D EC
 IPP Rev:C 07-05-28 As per Rev F JLM
 IPP Rev:D 07-12-04 ECN 1072 DD verified by:JLM
 IPP Rev:E 08-09-08 ecn 08-510 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN3C4A 		Purchased	No			110	Each	1,792.000	24	24		10/12/16	
BOLT													

Location

Loc Qty

Loc Code

ST245

32

M115936

X24

109061

5

110139

27

ST303

42

115438

42

ST350

1718

114108

14

114416

12

114523

2

115300

690

115589

1000

AN3C6A



Purchased

No

110

Each

269.0000

12

12

BOLT

Location

Loc Qty

Loc Code

ST351

269

111982

269

X12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Parent Item Name: Replacement Float Skidtube

Start Date: 10/4/2010

Required Date: 10/15/2010

Start Qty: 1.00

Required Qty: 1.00

AN3C7A Purchased No 110 Each 110.0000 8 8
BOLT

Location Loc Qty Loc Code
ST351 110
113149 81
114382 29

AN960C10L NAS1149C0332 Purchased No 110 Each 29.0000 44 44
washer

Location Loc Qty Loc Code
ST245 29
107534 29

D3391-021 Manufactured No 110 Each 0.0000 1 1
Fwd Tube Assembly
D3391-023 Manufactured No 110 Each 1.0000 1 1
Mid Tube Assembly

Location Loc Qty Loc Code
FP 1
40522 1

D3391-025 Manufactured No 110 Each 1.0000 1 1
Aft Tube Assembly

Location Loc Qty Loc Code
FP 1 B61869
48122 1

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Parent Item Name: Replacement Float Skidtube

Start Date: 10/4/2010

Required Date: 10/15/2010

Start Qty: 1.00

Required Qty: 1.00

D3564-1 Manufactured No

110 Each

14.0000

1

1



Wearshoe



20 10/12/16

Location

Loc Qty

Loc Code

FG

2

B51676

21

33798

2

FP19

12

58823

12

D3564-3 Manufactured No

110 Each

8.0000

1

1



Wearshoe



20 10/12/16

Location

Loc Qty

Loc Code

FG

2

33764

2

FP19

6

55489

1

58825

5

21

D3564-5 Manufactured No

110 Each

24.0000

1

1



Wearshoe



20 10/12/16

Location

Loc Qty

Loc Code

FG

1

34806

1

FP19

8

57525

1

58709

1

61699

6

FP-19

15

60868

2

62237

13

21

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Parent Item Name: Replacement Float Skidtube

Start Date: 10/4/2010

Required Date: 10/15/2010

Start Qty: 1.00

Required Qty: 1.00

D3566-1 Manufactured No

110

Each

25.0000

2

2



Gasket



10/12/16

Location

Loc Qty

Loc Code

FP015

25

1362892

X2

57715

2

60202

10

61992

13

D3566-5 Manufactured No

110

Each

11.0000

1

1



Gasket



10/12/16

Location

Loc Qty

Loc Code

FP

11

1363574

X1

60869

11

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Shop Packet Print

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